

Split v/c
SP 08/03/08Date: Thursday, 3/13/2008 10:20:34 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	PLATE
Job Number	37932-2	Part Number	D32191
Estimate Number	10425	Drawing Number	D3219 REV A
P.O. Number		Project Number	N/A
This Issue	3/13/2008	Drawing Revision	A
Prsht Rev.	NC	Material	
First Issue	11	Due Date	4/25/2008
Previous Run	37886	Qty:	40
Written By		Um:	Each
Checked & Approved By			
Comment	Est. A 04.04.19 New issue KJ/JLM ESR B 06.05.25 Waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S125	6061-T6 .125 Sheet	
			 Comment: Qty.: 0.1012 sf(s)/Unit Total : 4.0488 sf(s) 6061-T6 .125 Sheet To be made in multiples of 4 Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: <u>105646</u> <u>B 8-3-17</u>
2.0	WATER JET	FLOW WATER JET	 Comment: FLOW WATER JET 1-Cut as per Dwg D3219 Dwg Rev: <u>A</u> <u>B 8-3-17</u> Prog Rev: <u>A</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <u>B 8-3-17</u> Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK	 <u>B 8-3-17</u> Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	 <u>B 8-3-17</u> Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3219-1 PAR #: N/A Fault Category: Prod Fab Ass ^{med & small water jet.} NCR: Yes No DQA: DD Date: 08/04/04
D350-511 QA: N/C Closed: DD Date: 08/04/04

NCR: <u>37932</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/04/04</u>	<u>DD</u>	<u>3 parts found with knuckles from the water jet.</u>	<u>1</u> <u>08/04/04</u>	<u>SCRAP and Destroy no Replace. Qty <u>(x3)</u></u>	<u>B 8-4-1</u>	<u>C 08/04/04</u>	<u>1</u> <u>08/04/04</u>	<u>1</u> <u>08/04/04</u>

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:20:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 37932

Part Number: D32191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WT

MF 08-04-02 31

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-02

W

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37932
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

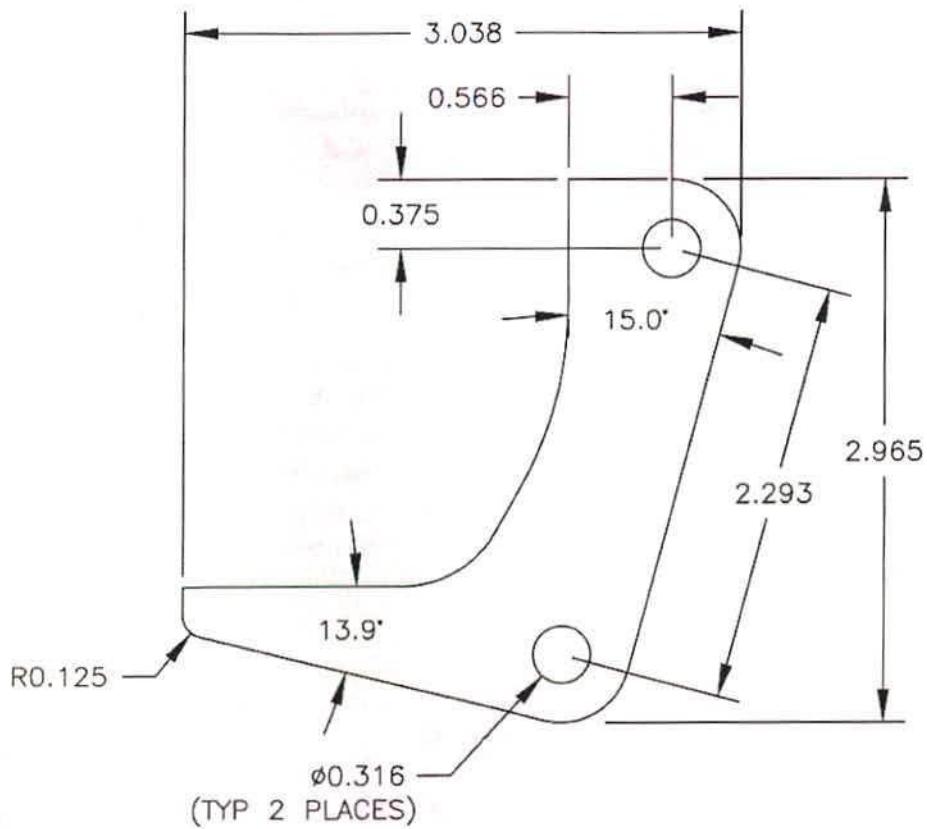
First Article Prototype

Measured by:	HB	Audited by:	✓	Prototype Approval:	N/A
Date:	8-3-17	Date:	08/04/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	
B	07.09.06	13.9° dimension added	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D3219 REV. A SHEET 1 OF 1
DATE	03.10.10			TITLE PLATE SCALE 1:1
	A	03.10.10		NEW ISSUE

RELEASED
04.04.05 ✓**D3219-1 PLATE**

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37932